

Work Order ID 71205

Thursday, June 23, 2011 1:28:51 PM



Page 1

Item ID: D3778-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 6/23/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/30/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: W Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3778

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3778 ☒ Dwg Rev: A ☐ Prog Rev: A ☐

SOS . 090

grain direction along 2.34" * 12-Deburr if necessary

B11-6-29

(16)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-6-29

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sulocetg

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Thursday, June 23, 2011 1:28:51 PM

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Accept

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-deburr

□2-Bend as per Dwg D3778

SB 1107/05

14

140

QC5- Inspect part completeness to step on W/O

0.00

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8407106

x16

150

Chemical Conversion Coat per QSI005 4.1

0.00

Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

16 of Bk 11-76

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

Powder Coating

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

16 0 M/L 11/07/12

16 0 M/L 11/07/12

11/11/12 0 100

M 115128

9:50
10:20
320°F

228

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/13

MF 11-07-13

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Thursday, June 23, 2011 1:28:48 PM

Table 1 Demographic characteristics of study population



	N (%)
Gender	
Male	60 (78.9)
Female	16 (21.1)
Age group (years)	
< 18	1 (1.3)
18–24	10 (13.3)
25–34	16 (21.1)
35–44	13 (17.3)
45–54	10 (13.3)
≥ 55	10 (13.3)
Ethnicity	
Chinese	10 (13.3)
Malay	10 (13.3)
Indian	10 (13.3)
Others	10 (13.3)
Marital status	
Single	10 (13.3)
Married	10 (13.3)
Divorced	10 (13.3)
Widowed	10 (13.3)
Education level	
Primary school or below	10 (13.3)
Secondary school	10 (13.3)
Tertiary school	10 (13.3)
Postgraduate	10 (13.3)
Occupation	
Unemployed	10 (13.3)
Self-employed	10 (13.3)
Employee	10 (13.3)
Retiree	10 (13.3)

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Required Date: 6/30/2011

Required Qty: 12.00

Comments: IPP Rev:A new issue 08-04-15 DD verified by:EC
IPP Rev:B 08-05-14 revA as per ECN1171 DD verified by:EC
IPP Rev:C 08-05-22 add powder coating DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.090		Purchased	No			100	sf	20.9000	0.0934	1.179789	1.5		
 													
5052-H32.090 Sheet													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						MAT22	20.9						
						3019	20.9						
									<div style="border: 1px solid black; border-radius: 50%; width: 40px; height: 40px; display: flex; align-items: center; justify-content: center; margin: 0 auto;">16</div>				
									<div style="border: 1px solid black; border-radius: 50%; width: 40px; height: 40px; display: flex; align-items: center; justify-content: center; margin: 0 auto;">3019</div>				

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NOTE: Date & initial all entries

7/205

☒ **First Article** ☐ **Prototype**

Measured by: RB	Audited by: JS	Prototype Approval:	N/A
Date: 11-6-29	Date: 11/06/29	Date:	N/A

by *A*

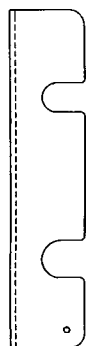
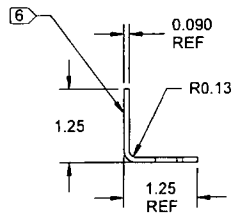
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

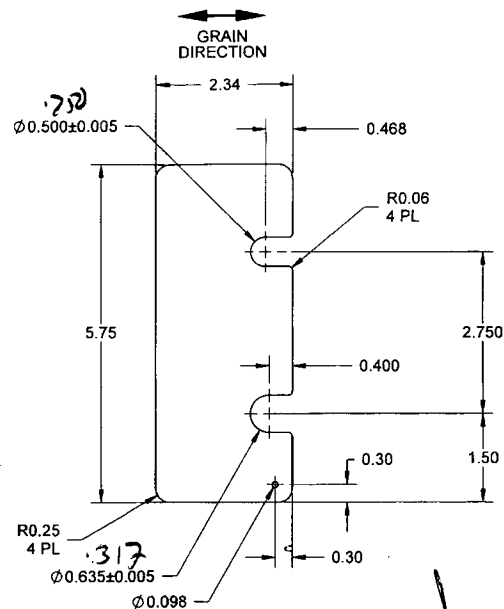
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D3778-1 BRACKET



D3778-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.090 THICK PER AMS-QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32.090)
OR
6061-T6/-T62 ALUMINUM SHEET, 0.090 THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T60.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3778-1" USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.11 lbs

A	NEW ISSUE	PH	08.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3778	SHEET 1 OF 1
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	BRACKET	NTS
DATE	08.04.11	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
08.05.11

2.183
1.183
2/07/2011

W/O:		WORK ORDER CHANGES					
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